

Date: Thursday, 3/9/2006 7:56:24 AM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : PEDAL ASSEMBLY
<b>Job Number</b> : 26150	
<b>Estimate Number</b> : 11005	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D412704041
<b>This Issue</b> : 3/9/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : IIN-D412-704 PG6,11
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : 3/8/2006 <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 26150	<b>Material</b> : N/A
<b>Written By</b> : <u>See comment below</u>	<b>Due Date</b> : 3/15/2006 <b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>06.03.08</u>	
<b>Comment</b> : Est Rev:B 05.01.28 Removed hardware on Step 2; Added Figures 1-3 KJ/RF	
Est Rev:C 06.03.08 Re-format EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1



**Comment:** SMALL & MEDIUM FAB RESOURCE 1  
 Assemble pedal as per Dwg IIN-D412-704 and Figures 1-3  
 Note: Only engage one thread on each bolt.

2.0	D3204041	Pedal Assembly
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 Pick:  

Qty	Part number	Description	batch
1	D3204-041	Pedal Assembly	B23524 ✓

3.0	D32051	Bracket
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 Pick:  

Qty	Part number	Description	batch
* 1	D3205-1	Bracket	B25964 ✓

4.0	D32053	Back Plate
-----	--------	------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 Pick:  

Qty	Part number	Description	batch
* 1	D3205-3	GHW Bracket	B26001 ✓

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 26150

Part Number: D412704041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D32061

Pedal Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	D3206-1	Pedal arm	B26153 ✓

6.0

D3209041

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	D3209-.041	Bracket	1 x B23194 / 3 x B23527 ✓

7.0

AN310A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	AN3-10A	Bolt	M17566 ✓

8.0

AN3154R

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	AN315-4R	Nut	M17566 ✓

9.0

AN410A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	AN4-10A	Bolt	M18057 ✓

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Job Number: 26150

Part Number: D412704041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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10.0	AN412A	Bolt
------	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part number	Description	batch
2	AN4-12A	Bolt	M18822 ✓

11.0	AN413A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	AN4-13A	Bolt	M19099 ✓

12.0	AN960JD10	Washer
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Comment: Qty.: 5.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part number	Description	batch
5	AN960JD10	Washer	M19521 ✓

13.0	AN960JD416	Washer
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Comment: Qty.: 11.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty	Part number	Description	batch
11	AN960JD416	Washer	M19085 ✓

14.0	AN960JD416L	Washer
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part number	Description	batch
3	AN960JD416L	Washer	M100229 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 26150

Part Number: D412704041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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15.0	MS21042L3	Nut
------	-----------	-----



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part number	Description	batch
3	MS21042L3	Nut	m18917 ✓

16.0	MS21042L4	Nut
------	-----------	-----



Comment: Qty.: 5.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part number	Description	batch
5	MS21042L4	Nut	m19099 ✓

17.0	MS24694S102	Screw
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	MS24694S102	Screw	m14604 ✓

18.0	MS951910	Bolt
------	----------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	MS9519-10	Bolt	1XB15159/3Xm100290 ✓

19.0	AN960JD10L	Washer
------	------------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty	Part number	Description	batch
4	AN960JD10L	Washer	m18235 ✓

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: SD Date: 06/01/13  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: PEDAL ASSEMBLY

Job Number: 26150

Part Number: D412704041

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN36A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty

Part number

Description

batch

2/5

AN3-6A

Bolt

m18950 ✓

C 206/04/03 (4)

21.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

P 4/4/12 (4)

22.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

C 4/4/12 (4)

23.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

(4) (4)

Job Completion



U 06-04-13

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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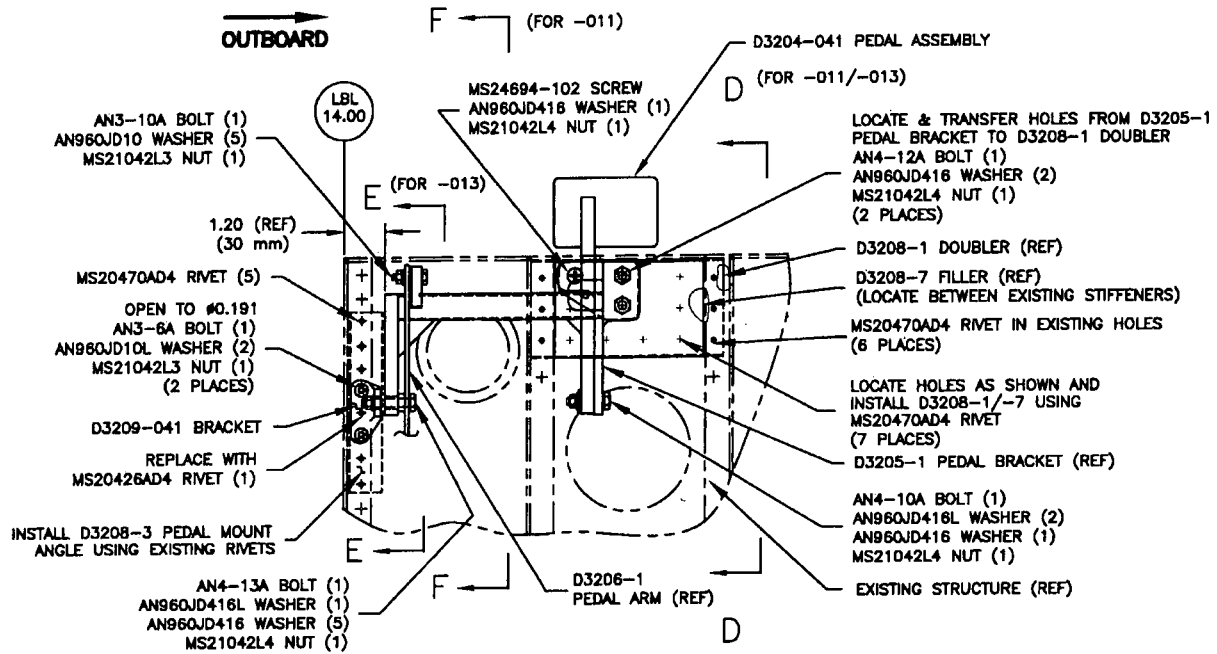


Figure 2 – Detail A. View looking AFT  
(Co-pilot's Side -011/-013 Installations).

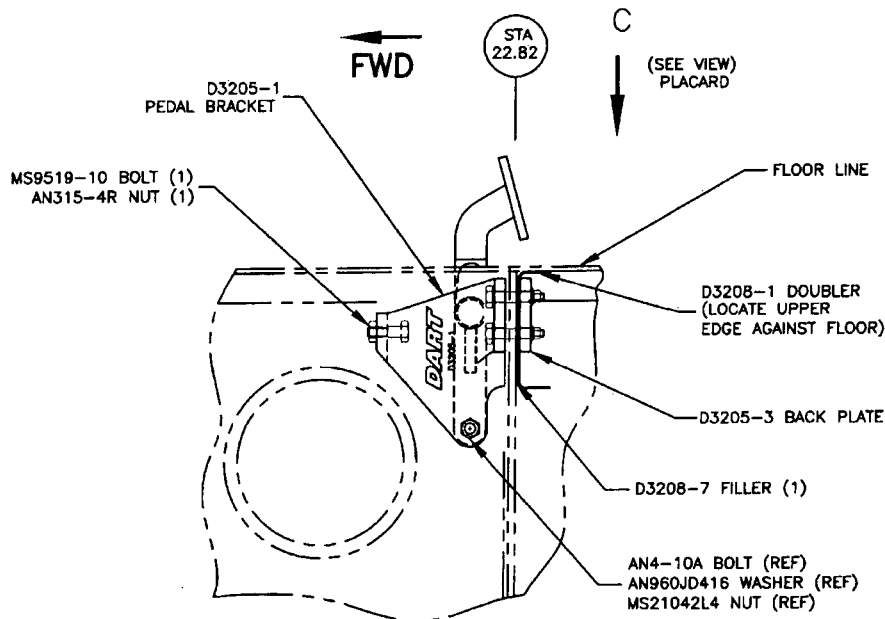


Figure 3 – View D-D. View looking Inboard  
(-011/-013 Installations)

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Revision: **A**  
Date: 04.02.03

## 5.0 PARTS LIST

Qty -011	Qty -013	Qty -041	Qty -043	Qty -045	Part Number	Description
X					D412-704-011	COPILOT'S EMERGENCY CARGO RELEASE KIT (BELL 212/ 214 / 412)
	X				D205-704-013	COPILOT'S EMERGENCY CARGO RELEASE KIT (BELL 205)
1	1	X			D412-704-041	PEDAL ASSEMBLY (205/ 212/ 214/ 412)
	1		X		D205-704-043	CABLE ASSEMBLY (205)
1				X	D412-704-045	CABLE ASSEMBLY (212/ 214/ 412)
		1			D3204-041	PEDAL ASSEMBLY (OR ECM 999702-1)
		1			D3205-1	PEDAL BRACKET (OR ECM 999703-1)
		1			D3205-3	BACK PLATE (OR ECM 999709-5)
		1			D3206-1	PEDAL ARM (OR ECM 999704-1)
	1				D3207-1	BRACKET
1					D3207-2	BRACKET
	1				D3207-3	BRACKET
1					D3207-5	BRACKET
1	1				D3208-1	DOUBLER (OR ECM 999709-1)
1					D3208-11	FILLER
1	1				D3208-3	PEDAL MOUNT ANGLE (OR ECM 999709-7)
	1				D3208-5	MOUNT ANGLE
1	1				D3208-7	FILLER (OR ECM 999709-3)
1					D3208-9	DOUBLER
		1			D3209-041	BRACKET ASSEMBLY (OR BHT 204-070-993-001)
1	1				D3214-1	PLACARD (OR ECM 999712-1)
			1		D3217-1	CABLE
				1	D3217-3	CABLE
			1	1	D3257-1	FITTING
			1	1	D3258-1	ANGLE BRACKET
		1			AN315-4R	NUT
		5	2	2	AN960JD10	WASHER
		4	2	2	AN960JD10L	WASHER
		11			AN960JD416	WASHER
		3			AN960JD416L	WASHER
			3	3	NAS509-3	NUT
		3	2	2	MS21042L3	NUT (OR MS21042-3)
		5			MS21042L4	NUT (OR MS21042-4)
4	4				MS21919DG5	CLAMP
		1			MS24694-S102	SCREW
	2				MS35489-10	GROMMET
			1	1	AN3-5A	BOLT
		2			AN3-6A	BOLT
		1			AN3-10A	BOLT
			1	1	AN3-13A	BOLT
		1			MS9519-10	BOLT
		1			AN4-10A	BOLT
		2			AN4-12A	BOLT
		1			AN4-13A	BOLT

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Revision: A

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